

Work Order ID 73705

Wednesday, September 14, 2011 9:13:56 AM



Page 1

Item ID: D2571

Accept



Setup Start



Revision ID:

Item Name: Saddle, Fwd Out 205

Stop



Start Date: 9/14/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/02/14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2571

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

B.A. 11/11/02
aml

HAAS 1

0.00

HAAS CNC vertical machine #1

Memo

Program Batch No. 73705 Double check by: aml ☐ 1-Machine Step No 1
per Folio FA051 and inspect per attached Dimension Sheets ☐ 2-Machine Step
No 2 per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-Machine
Step No 3 per Folio FA051 and inspect

12 0

110

0.00



CONVENTIONAL MILLING MACHINE

B.A. 11/11/11

Mill Conv

0.00

Conventional Milling Machine

Memo

Machine keyway as per dwg D2571 & D2572

12 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

aml 11/11/08

QC

0.00

Quality Control

Memo

12 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73705

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Page 2

Item ID:	D2571	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle, Fwd Out 205					
Start Date:	9/14/2011	Start Qty:	12.00		Cust Item ID:	
Required Date:	9/30/2011	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	JL	11-11-12		12			
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							

12x0 m-f 11/14/14

12x0 m-f 11/14/14

W118434

12:00
START TIME: 3200F
FINISH TIME: 12:30
OVEN TEMPERATURE:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 73705

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Page 3

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Setup Start

Revision ID:

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Item Name: Saddle, Fwd Out 205

Start Date: 9/14/2011 Start Qty: 12.00

Required Date: 9/30/2011 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish 0.00



QC Memo 0.00

Quality Control

12 BR 11-11-14

170 Identify as per dwg & Stock Location: _____ 0.00



Packaging Memo 0.00

Packaging

Carpenter 12

180 QC21- Final Inspection - Work Order Release 0.00



QC Memo 0.00

Quality Control

11/11/14
mk
11-11-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 14, 2011 9:13:53 AM

Page 1

Work Order ID: 73705

Parent Item: D2571

Parent Item Name: Saddle, Fwd Out 205


Start Date: 9/14/2011

Required Date: 9/30/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated
D2572 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007 		Manufactured	No			100	Each	41.0000	1	12			

Saddle Billet

Location	Loc Qty	Loc Code
MAT	8	
71722	8	
MAT042	22	
72228	2	
73421	20	
MAT045	11	
65383	1	
65954	4	
70680	6	

12

amh uln/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	73705
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.002		
F	0.490	0.510		.500	.506	.502	.504		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.376	.377	.377	.377		
I	0.490	0.510		.499	.497	.500	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.565	.568	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.873	3.873	3.873		
P	0.115	0.135		.127	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.251	.251	.252		
S	0.115	0.135		.133	.133	.131	.132		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.235	.237	.237	.237		
W	0.115	0.135		.125	.123	.121	.123		
X	0.308	0.313		.308	.308	.308	.308		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.359	.360	.359	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.627	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.243	.247	.245	.247		
AE	1.375	1.395		1.3898	1.3874	1.387	1.386		
AF	0.115	0.135		.133	.133	.127	.130		
AG	0.240	0.280		.265	.265	.260	.260		
AH	0.240	0.260		.245	.248	.247	.248		
AI	2.000	2.020		2.0045	2.003	2.002	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	cmk
Date:	11/11/03

Audited by:	L
Date:	11/11/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	73705
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	37	48		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.000	8.000	8.000		
F	0.490	0.510		.501	.501	.500	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.499	.499	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.566	.565	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.873	3.873	3.873		
P	0.115	0.135		.125	.125	.126	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.253	.252	.253	.252		
S	0.115	0.135		.132	.133	.131	.133		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.238	.238	.237	.237		
W	0.115	0.135		.127	.128	.122	.126		
X	0.308	0.313		.308	.308	.308	.308		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.361	.359	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.625	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.245	.246	.246		
AE	1.375	1.395		1.386	1.3865	1.3885	1.387		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.260	.260	.265	.265		
AH	0.240	0.260		.249	.249	.249	.249		
AI	2.000	2.020		2.002	2.002	2.0025	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	cmf
Date:	11/10/12

Audited by:	J
Date:	11-11-12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	73705
Description: Saddle, Fwd Outboard		Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				7/9	7/10	7/11	7/12		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.502	.502	.502	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.567	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.873	3.873	3.873		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.251	.253	.252		
S	0.115	0.135		.133	.132	.133	.133		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.238	.238	.238	.236		
W	0.115	0.135		.126	.126	.123	.126		
X	0.308	0.313		.308	.308	.308	.308		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.359	.360	.362	.361		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.248	.246	.247		
AE	1.375	1.395		1.3875	1.387	1.387	1.387		
AF	0.115	0.135		.130	.130	.130	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.249	.250	.249		
AI	2.000	2.020		2.0025	2.0015	2.0016	2.002		
AJ	0.023	0.043							
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	11/11/08

Audited by:	JL
Date:	11-11-12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
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